LHe Tank Radiograph Reports

CONAM

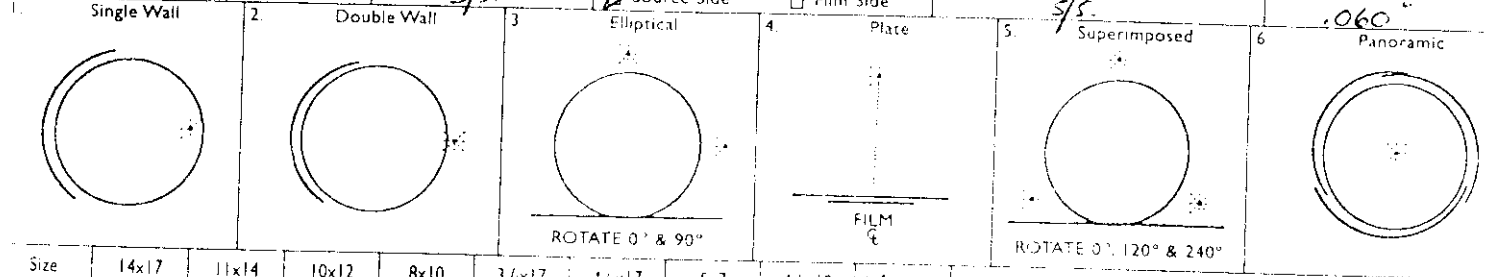
LHe TANK
G BOX

Radiographic Inspection Report

Page 1 Of 1

Customer: MEYER TOOL & MFG.	Contract # /PO: 008404-00	Job #: 1376/G270	Date: 6/27/03
Specification: ASME SEC. VIII. AMEND #4	Method Specification: 96-RT-005 REV. 4	Acceptance Standard: ASME SEC. VIII. APPENDIX - 4	
Plate Thickness: .312"	Pipe Diameter: N/A	Weld Thickness: .312" + CAP	Joint Type: BUTT / Material: S/S.
Radiation Source: IR-192	Source Strength: 76 CI.	Focal Spot Size: .148"	Technique Used: #4
Part Description: S/S CHAMBER	Film Technique: ☐ Single ☐ Multiple	Film to Source Distance: 14"	Exposure Time: 1-MIN-20 SECOND
Film Processing: ☑ Automatic ☐ Manual	Intensifying Screens: Pb.	Front: .010"	Center: — / Back: .010"
Type Penetrameter: ASTM - 15	Material: S/S.	Penetrameter Location: ☑ Source Side ☐ Film Side	Shim Material: S/S. / Shim Thickness: .060"

1. Single Wall 2. Double Wall 3. Elliptical 4. Plate 5. Superimposed 6. Panoramic



Size	14x17	11x14	10x12	8x10	3/.x17	4/.x17	5x7	4/.x10	Kodak
TYPE & NO.								4	"M"

Job Location: LAB #596

Rad - ID #		Original or Repair	Geometric Unsharpness "Ug"	Accept	Reject	Porosity	Inclusions	Cracks	Incomplete Fusion	Inadequate Penetration	Undercut	Burn Thru	Root Concavity	Film Artifact	Remarks	Penetrometer Density	Weld Density
PART # 25I111G																	
W# "A"	A-B	OR	.003"		✓				X					✓		2.67	2.62
W# "B"	A-B	↓	↓	✓		✓								✓		2.62	2.55
W# "C"	A-B			✓		✓								✓		2.63	2.74
W# "D"	A-B			✓		✓								✓		2.58	2.66

Film Reviewer/Inspector: DENNIS KUTSCHRAU Signature: Dennis J. Kutschrau LVL III. Date: 6/27/03

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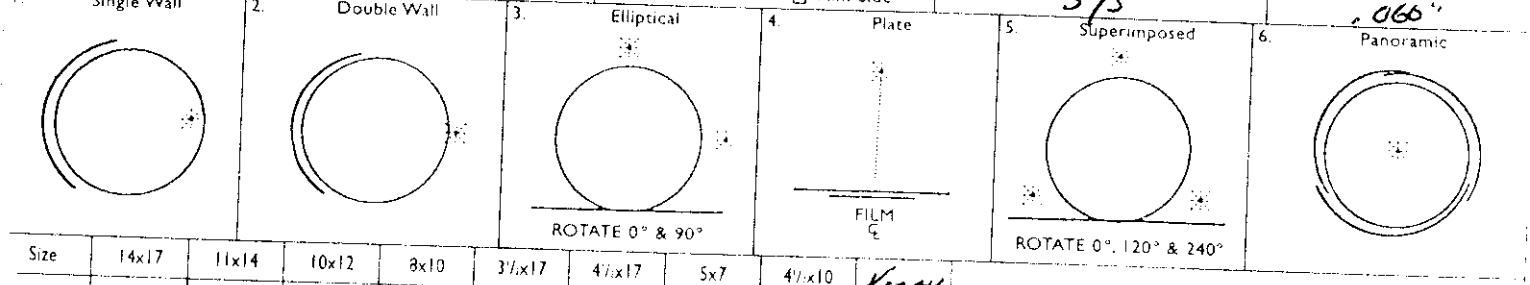
G BEX

Radiographic Inspection Report

Page 1 Of 1

Customer: MEYER TOOL + MFG	Contract # /PO: 8924-00	Job #: 1376/6270	Date: 7-3-03
Specification: ASME SEC V	Method Specification: 96-RT-005 R/4	Acceptance Standard: ASME SEC VIII APPENDIX 4	
Plate Thickness: .312"	Pipe Diameter: —	Weld Thickness: .312" + CROWN	Joint Type: BUTT / Material: S/S
Radiation Source: X-RAY TUBE	Source Strength: 250 KV 8 MA	Focal Spot Size: .177"	Technique Used: #4
Part Description: S/S CHAMBER	Film Technique: ☑ Single ☐ Multiple	Film to Source Distance: 42"	Exposure Time: 40 SEC
Film Processing: ☑ Automatic ☐ Manual	Intensifying Screens: Pb	Front: .010" / Center: —	Back: .010"
Type Penetrameter: ASTM #15	Material: S/S	Penetrameter Location: ☑ Source Side ☐ Film Side	Shim Material: S/S / Shim Thickness: .060"



Size	14x17	11x14	10x12	8x10	3½x17	4½x17	5x7	4½x10	KODAK "M"
TYPE & NO								1	

Job Location: LAB

Rad - ID #	Original or Repair	Geometric Unsharpness "Ug"	Accept	Reject	Porosity	Inclusions	Cracks	Incomplete Fusion	Inadequate Penetration	Undercut	Burn Thru	Root Concavity	Film Artifact	Remarks	Penetrometer Density	Weld Density
25 I 111 R		.001"														
WELD A A-B	R1		✓						✓						1.89	2.05

Film Reviewer/Inspector: JEFF OURS RT II Signature: Jeff Ours Date: 7/3/03

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